Work Order ID 62426

September 30, 2010 7:59:40 AM

Item ID: D4172-7 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Crossbar

Start Date: 9/30/10 **Start Qty:** 5.00 **Cust Item ID:**

Required Date: 10/08/10 **Req'd Qty:** 5.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 10/9/30 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4172 / A		~~ML 10/10/04~~				5x			
100		0.00							
Small Fab	**Memo**	0.00							
Small Fab	1- Cut to lenght as per dwg 2- Use DT9661 to drill holes in angle, open to size as per dwg 3- C'sink holes as per dwg 4- Deburr holes	→ ML				10/10/04			
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control		8/10/10/05				x5			
120	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing		BR 10-10-6				5	ø		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 62426

September 30, 2010 7:59:40 AM

Item ID: D4172-7
Revision ID:
Item Name: Crossbar
Start Date: 9/30/10 **Start Qty:** 5.00
Required Date: 10/08/10 **Req'd Qty:** 5.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00	=7M	10/10/06		5	Ø		
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: 134	0.00				10/10/06	SP	(SP)	
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00						10/10/07	
QC	Memo	0.00							
Quality Control									

MF 10-10-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 30, 2010 7:59:40 AM

Work Order ID: 62426

Parent Item: D4172-7

Parent Item Name: Crossbar

Start Date: 9/30/10 **Required Date:** 10/08/10

Start Qty: 5.00 **Required Qty:** 5.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A1.000W.125 6061T6 ANGLE 1.00 x 1.00 x .125W		Purchased	No			100	f	90.9100	1.3453	7.080526 M-L		10/10/04	

Location	Loc Qty	Loc Code
MAT	90.91	
115688	10.91	
115776	80	

7-080526

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

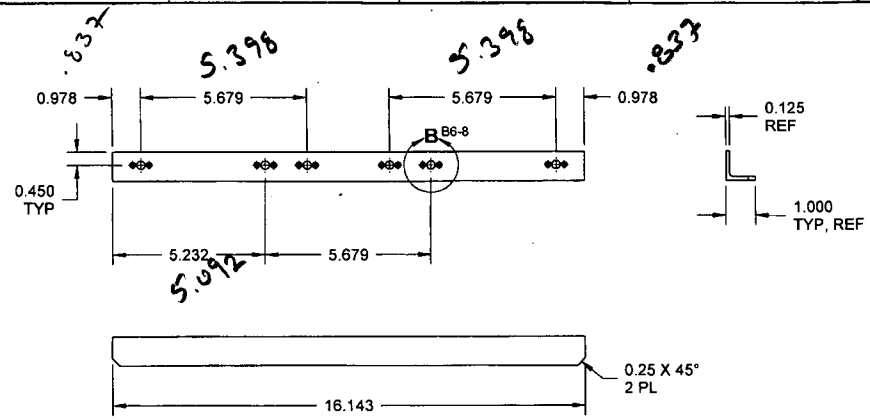
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

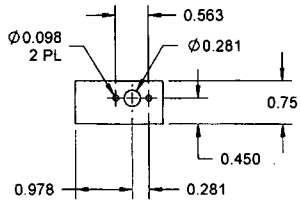
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

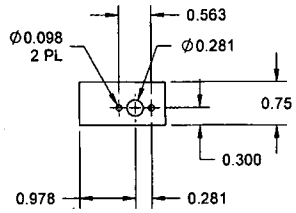
NOTE: Date & initial all entries

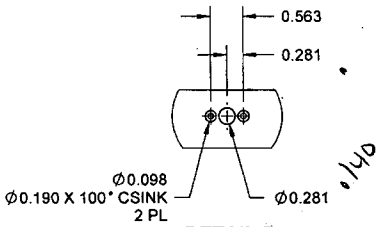
H:\FORMS\Quality Assurance\approved QA\NCRWO RevE



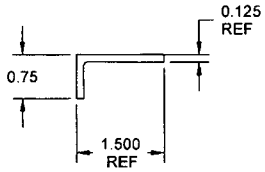
D4172-7 CROSSBAR



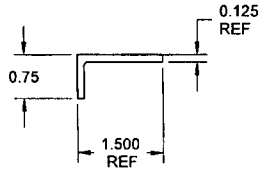




DETAIL B D6-8
SCALE 2X
TYP



D4172-9 ANGLE



D4172-10 ANGLE

CL1019130
W10:62426

RELEASED
2010-09-29

NOTES:
1) MATERIAL
D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6207
D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6203
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D4172 — REV. A — SHEET 7 OF 7
CHECKED		TITLE: POD MOUNTING FRAME ASSY — SCALE: NTS
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.09.15	